

# Work Order ID · 68669



Page 1

Tuesday, April 19, 2011 3:56:43 PM

Item ID: D135-692-011 *U*

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 4/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *[Signature]*

Date: *4-04-19*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3049

Rev A1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D135-692-011 CHG002

*Sularic*

*4th Page*  
*for BG 11-9-16*

150

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

*sl*

*sp 11-09-16*

160

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

*Sularic*

*(x2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID - 68669**

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Tuesday, April 19, 2011 3:56:43 PM

Item ID: D135-692-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 4/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D135-692-011

Location: 11APPP Rev: C

11/11/08

2

180

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

11/9/13

ME  
11-09-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, April 19, 2011 3:56:51 PM

Page 1

Work Order ID: 68669

Parent Item: D135-692-011

Parent Item Name: Bearpaw

Start Date: 4/19/2011

Required Date: 4/25/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C04.02.17 Blank size changed, Tolerance added Step 3 KJ/JLM  
IPP Rev:D 08-04-16 Added Step 2 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-15A		Purchased	No			160	Each	471.0000	8				
---------	--	-----------	----	--	--	-----	------	----------	---	--	--	--	--



Bolt

Location	Loc Qty	Loc Code
ST308	71	
116786	71	
ST357	200	
117423	200	
ST358	200	
117313	200	

8  
m 11812 5x  
m 11864811x  
SP 11-09-16

AN960JD416	NAS1149D0463J	Purchased	No			160	Each	0.0000	8	16			
------------	---------------	-----------	----	--	--	-----	------	--------	---	----	--	--	--



Washer

D2182B



Rubber Cushion

m 118384 16x

Location	Loc Qty	Loc Code
ST410	347.3169	
66063	347.3169	

8 16  
SP 11-09-16  
2 4  
SP 11-09-16

(D2182B060) Cut 4 at 6.00"

D2274



Radius Block

Manufactured	No		160	Each	528.0000	8	16
--------------	----	--	-----	------	----------	---	----

Location	Loc Qty	Loc Code
ST010	528	
65757	124	
67578	404	

8 16  
SP 11-09-16

B69736 16x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, April 19, 2011 3:56:51 PM

Work Order ID: 68669

Parent Item: D135-692-011

Parent Item Name: Bearpaw

Start Date: 4/19/2011

Required Date: 4/25/2011

Start Qty: 2.00

Required Qty: 2.00

S  
+1  
D2519  
Clamp

Manufactured No 160 Each

55.0000

8/16  
Sp 11-09-16  
P12 →

Location

Loc Qty

Loc Code

ST462

55

62078

5

65118

50

Manufactured No

160 Each

641.0000

8

16



Sp 11-09-16

S  
+1  
D2529  
Washer

Location

Loc Qty

Loc Code

ST016

641

64127

141

66953

500

Manufactured No

160 Each

0.0000

2

4



68670 P4/10

S  
D3049-1  
Bearpaw

MS21042L4

Purchased No

160 Each

5,442.000

8

16



Sp 11-09-16

S  
Nut

Location

Loc Qty

Loc Code

ST300

5442

116188

442

116823

2000

117441

3000

m 117885 16x

W/O: 68669		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

App 11-60 for Eng to review  
 see e-mail attached

Part No: D135-692-011 PAR #: \_\_\_\_\_ Fault Category: Palutic Eng NCR: Yes No DQA: CF Date: 11/09/20  
 Resolution: Re work Disposition: Re work QA: N/C Closed: CF Date: 11/09/20

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/09/16	#100	incorrect amount to pick for D2519 R.L who is incorrect work	11/09/19	ADD musin qty to kit. (should be qty as per kit)	11/09/19	11/09/19	11/09/16	
				Adjust w/o + Bom. ADD copy of Bom A see e-mail attached pick list in IIN is correct.				11/09/16

CON 11-60 generated  
 CF 11/09/

NOTE: Date & initial all entries



# Picklist Print

Page 3

Tuesday, April 19, 2011 3:56:51 PM

Work Order ID: 68669



Parent Item: D135-692-011



Parent Item Name: Bearpaw

Start Date: 4/19/2011

Required Date: 4/25/2011

Start Qty: 2.00

Required Qty: 2.00

QS100-M24S

Purchased

No

160

Each

27.0000



Clamp



4 8

80 11-09-16

Location

Loc Qty

Loc Code

ST449

27

116513

2

117291

25

2x  
6x

Tuesday, April 19, 2011 3:56:51 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 32.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D135-692-011 Bearpaw Installation on model EC135 aircraft	11.8 lb 5.36 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	199.7 in 5.07 m	2356 in-lb 27.2 m-kg

## 32.4 PARTS LIST

Qty	Part Number	Description
<b>X</b>	<b>D135-692-011</b>	<b>BEARPAW INSTALLATION</b>
4	D2182B060	RUBBER CUSHION
8	D2274	RADIUS BLOCK
2	D3049-1	BEARPAW
8	D2529	WASHER
8	D2519	CLAMP
8	AN4-15A	BOLT
8	AN960JD416	WASHERS
8	MS21042L4	NUT (OR MS21042-4)
4	QS100M24S	CLAMP

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**32-00-00**

5. Additional AN960JD416 washers may be installed under the nuts to ensure 1.5-4 threads in safety on the bolts. Although not generally necessary, it is also acceptable to replace the AN4-15A bolts with longer or shorter AN4 bolts, if required.
6. Lower the aircraft

#### 4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D135-692-011 Bearpaw Installation on model EC135 aircraft	11.8 lb 5.36 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	199.7 in 5.07 m	2356 in-lb 27.2 m-kg

#### 5. PARTS LIST

Qty	Part Number	Description
X	D135-692-011	BEARPAW INSTALLATION
4	D2182B060	RUBBER CUSHION
8	D2274	RADIUS BLOCK
2	D3049-1	BEARPAW
8	D2529	WASHER
4	D2519	CLAMP
8	AN4-15A	BOLT
8	AN960JD416	WASHERS
8	MS21042L4	NUT (OR MS21042-4)
4	QS100M24S	CLAMP

## Cathy Kerr

---

**From:** David Duval <dduval@dartaero.com>  
**Sent:** Tuesday, September 20, 2011 10:29 AM  
**To:** ckerr@dartaero.com  
**Subject:** FW: D135-692-011

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**From:** David Shepherd [mailto:dshepherd@dartaero.com]  
**Sent:** September 20, 2011 10:19 AM  
**To:** 'David Duval'; 'Roberto Fuentes'; 'Eric Downing'  
**Cc:** 'Mike Petsche'  
**Subject:** RE: D135-692-011

Dave,

We do this kind of thing to keep you on your toes!

The pick list in the IIN is correct ... there should be 4 x D2519 clamps in the kit.  
Please generate a CAR to log this discrepancy so that we can (eventually) get it fixed.

Thanks,  
David

---

**From:** David Duval [mailto:dduval@dartaero.com]  
**Sent:** September-19-11 9:33 AM  
**To:** 'Roberto Fuentes'; Eric Downing  
**Cc:** David Shepherd; 'Mike Petsche'  
**Subject:** D135-692-011

Just wondering why is the IIN pick list different then the ICA (D2519 clamp different qty's)  
Which one is correct?

***David Duval***  
***Production Engineering Coordinator***  
1270 Aberdeen Street  
Hawkesbury Ontario  
Canada K6A 1K7  
Tel: (613) 632-5200  
[dduval@dartaero.com](mailto:dduval@dartaero.com)



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Corrective Action Report				CAR 11-60	
Raised by: C. Kerr		Source: J. Duval		Sheet No. ___ of ___	
Issue for Dept./Supplier: Prod / Coord.				Date: 11/09/20	
Product/Service: D2519 (D135-692-011)				Priority: HIGH LOW	
Area of Standard:		Section A			
QSI		Description of Issue:			
QSP		Quantity discrepancy between the			
QSPM		11W D135-692 qty 4 D2519			
		1CA D135-692 qty 8 D2519 - reduce qty to 4.			
Documents:					
P/O					
Invoice					
W/O					
Batch No.					
TSR		Root Cause: LCA			
Drawing					
Forward to Director, Quality Assurance on completion of Section A					
DQA: Section B: Indicate who is responsible for creating C/A, and a completion date. Section C: Indicate who will verify completion of C/A.					
<b>Section B</b> <b>Corrective Action</b>					
Responsible for Investigation/CA: M. Petsche To be done by: 11/09/30					
No	Initial	Action Description	Responsible	Due date	Sign/Date
1	ck	Review 1CA D135-692 to correct qty of the D2519 clamps.	M. P.	11/09/30	
Preventive Action Required: NO YES # _____					Fault Category: Design
<b>Section C</b> <b>Verification of C/A</b>					
Responsible for Verification of CA: _____					
No	Verification Method		Sign	Date	
					Forward to DQA on Completion of Verification
					DQA: _____
					Date: _____
QA Purposes only			C/A Closed		Date